

85952

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

5X

10

Cust Item ID:

10

Customer:

Reference:

Process Plan: *M.T*

Date: 17/06/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85952

85952

Page 2

June-19-12 8:02:26 AM

Item ID: D3912-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop *NS2*

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST507</u>	0.00							
170									
Packaging	Memo	0.00				5x			SP
Packaging									D-7-5
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							CK 12/7/6
Quality Control									

W/ 207-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-19-12 8:02:30 AM

Page 1

Work Order ID: 85952

85952

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R *NAS1149C0663R* Washer		Purchased	No				Each	159.0000		10		12/07/05	**
				<u>Location</u>				<u>Loc Qty</u>					
				ST297				159					
					116893			159					
D3912-1 *D3912-1* Eyebolt		Manufactured	No			100	Each	3.0000	1	10		12/07/05	**
				<u>Location</u>				<u>Loc Qty</u>					
				FG091				-12					
					69593			0					
				ST070				3					
					77073			2					
					82899			1					
				ST091				12					
D3912-3 *D3912-3* Eyebolt Block		Manufactured	No			100	Each	13.0000	2	20		12/07/05	**
				<u>Location</u>				<u>Loc Qty</u>					
				ST070				13					
					83366			1					
					85755			12					

50
B86020

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-19-12 8:02:30 AM

Page 2

Work Order ID: 85952

85952

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

D3912-5 Manufactured No

100 Each

5.0000

2

20

D3912-5

Eyebolt Plate

**

Location

Loc Qty

Loc Code

ST070

5

83367

5

D3801-1 Manufactured No

Each

96.0000

**

D3801-1

Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST064

96

75178

10

81860

46

82615

40

MS20615-4M20 Purchased No

100 Each

144.0000

8

80

MS20615-4M20

RIVET

**

Location

Loc Qty

Loc Code

FP

7

120644

7

GA

137

119546

26

121339

9

121463

102

MS21209-F615 Purchased No

Each

79.0000

**

MS21209-F615

Heli-Coil

Location

Loc Qty

Loc Code

ST304

79

121561

79

June-19-12 8:02:31 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

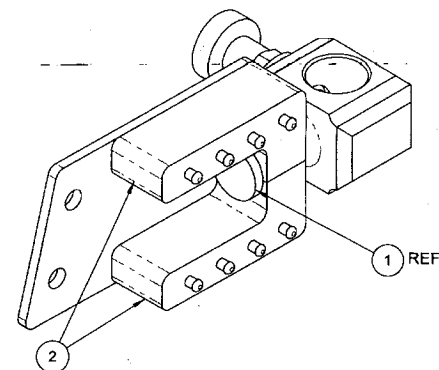
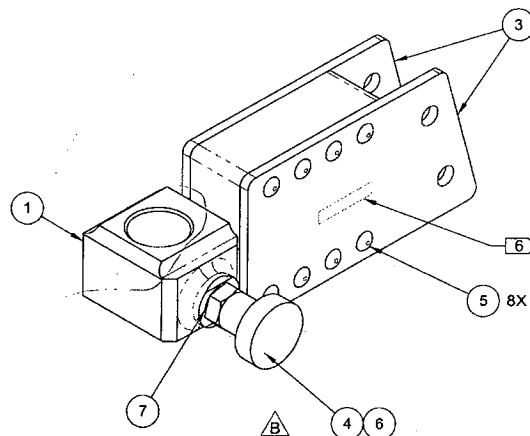
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85952 MLJ
12/06/19

SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	A/S		
DRAWN	J		
CHECKED	J		
MFG. APPR.	J		
APPROVED	J		
DE APPR.	J		
DATE	10.06.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3912	REV. B SHEET 1 OF 3
TITLE EYEBOLT RECEIVER ASSY	SCALE NTS
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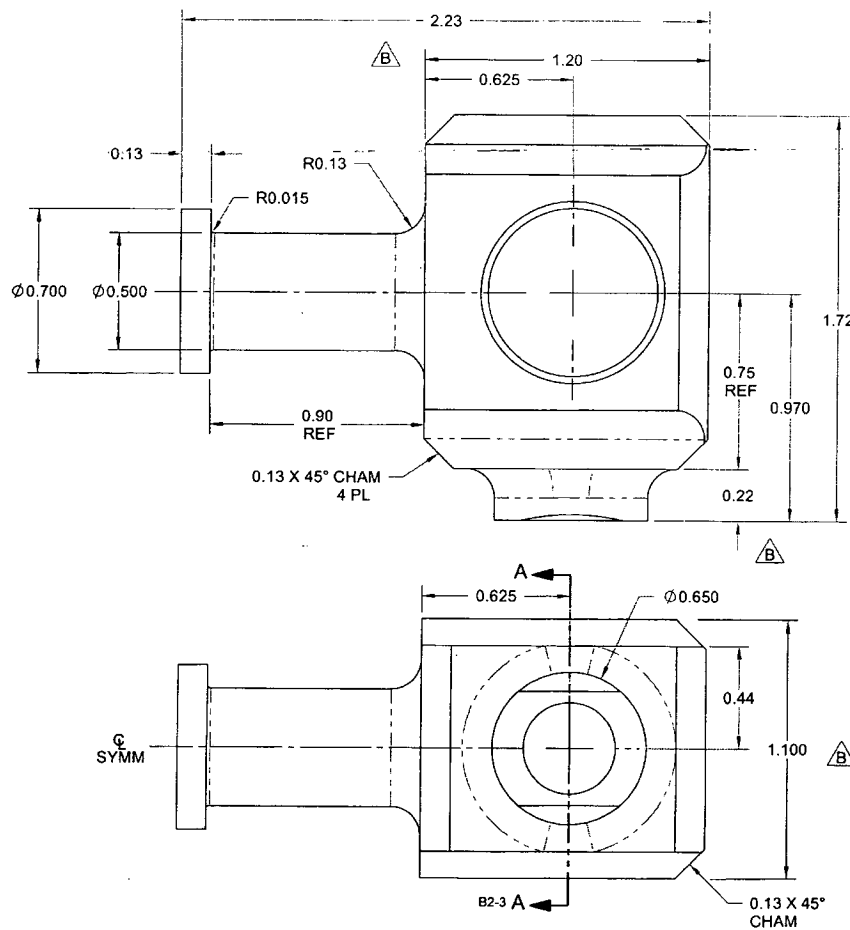
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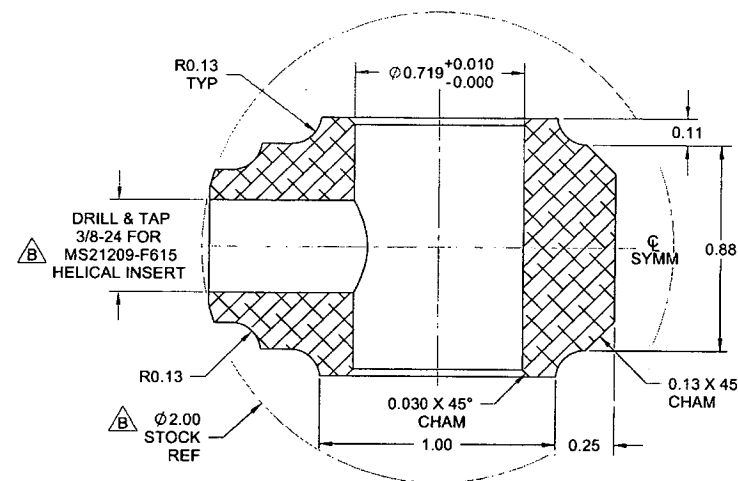
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	8/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9/1	DRAWING NO.	REV. B
MFG. APPR.	9/1	D3912	SHEET 2 OF 3
APPROVED	9/1	TITLE	SCALE
DE APPR.	9/1	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

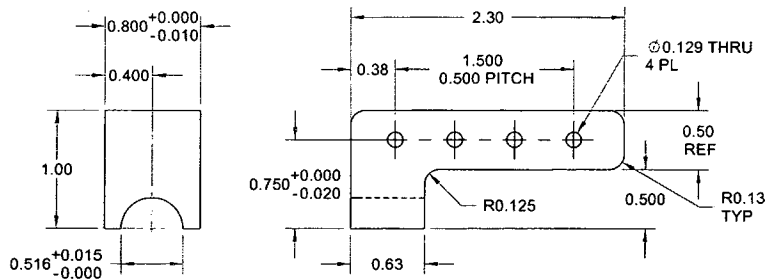
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

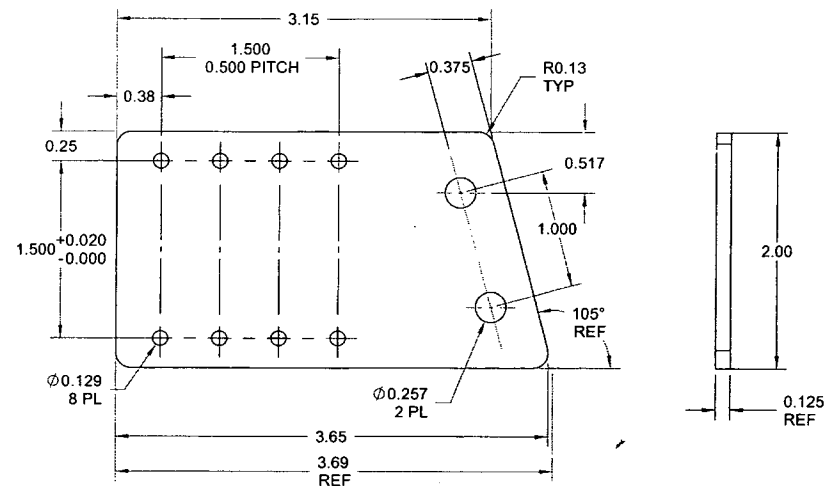
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
JMP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	8/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	8/1	DRAWING NO. D3912	REV. B
MFG. APPR.	8/1	SHEET 3 OF 3	
APPROVED	8/1	TITLE	SCALE
DE APPR.	8/1	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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